

Date: Monday, 22/12/2008 2:31:16 PM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LOW GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number : 44224A
Estimate Number : 11972
P.O. Number :
This Issue : 22/12/2008 S.O. No. :
Prsht Rev. : NC Part Number : D206642141
First Issue : / / Type : SKIDTUBES Drawing Number : D2650
Previous Run : 43433 Drawing Revision : F
Material :
Written By : Due Date : 20/01/2009 Qty: 1 Um: .Each
Checked & Approved By : MF 08-12-23
Comment : Est Rev:H 05.10.11 ECN 847 & 901; Add Tow Ring and GHW
Kit; CHG004 KJ/CP/JLM
Est Rev:I 08-06-10 chg D2654-3 to -1 (seq 13) DD verified
by:ec
Est Rev:J 08-07-14 remove QC5 at seq.41 DD verified by:EC
Est rev:K 08-09-29 revF as per dwg DD verified by:
Est Rev: L 08.11.27 QC10 replaces QC9 at step 24 KJ
Verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-141 CHG003

N/A *tg*

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD

B43845

SL 8-12-29

3.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1

Doubler

B413121

PM 09-01-05

4.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647

Fwd Cap

B43846

BE 08/12/30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R

Aluminum Rod

45816
m109560/m109213

BE 8-12-30

4-Grind weld flush to cap on top surface only.

BE 8-12-30

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per-Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8166 (A,B & C).

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove and Deburr D3286-1 doubler

13-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

15-Remove indexing edge using DT8741 as per Dwg D2650

16-Sink GHW rivet holes as per Dwg D2650

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/01/05

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes as per Dwg D2650 *fm 09-01-05*

2-Drill pilot holes using DT8028-1, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. *fm 09-01-05*

3-Deburr tube and blow out chips from inside the tube *fm 09-01-06*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *fm 09-01-06*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 09-01-06

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-1 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube *fm 09-01-06*

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

DP 9-1-06

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

52 CR3212-4-04 Rivet *m110772*

Pm 09-01-06

13.0

D26541

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s).

Web

batch: *B44279*

Pm 09-01-06

14.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required *Pm 09-01-06*

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: *09-01-06* Time: *2:45*

Finish Date: *09/01/07* Time: *8:30 AM*

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *m108883*

Sikaflex expire date: *09-07-11*

Pm 09-01-06

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/07 (40)

16.0

D2649

Cross Bolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 D2649 Crossbolt spacer *B 44276*

BE 09/01/07

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer *B 43862* *BE 09/01/07*

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44224A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M109213

BE 08/01/07

2-Grind welds flush as per Dwg D2650.

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE

BE 08/01/07

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

DP 9-1-13

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS33-3 Rivets

M110122

DP

DP 9-1-13

20.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivet

batch:

M110139

DP

9-1-13

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041

Nut Plate

B34599

DP

9-1-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44224A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Handwritten: 9-1-13

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

Handwritten: 509/1/13 (X)

24.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Handwritten: 509/01/13 (X)

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

Handwritten: FL 09/01/21 (D)

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

START TIME: *1:30pm*

OVEN TEMPERATURE: *320F*

FINISH TIME: *2:00pm*

Handwritten: JH 09-01-21 (X)

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: a.m 09.01.22 (D)

28.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

Handwritten: B44294

Handwritten: a.m 09.01.22 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44224A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265611

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-11

Wearshoe

B 35897

A.m 09.01.22

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B 43992

A.m 09.01.22

31.0

D265631

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-31

Wearshoe

B 41736

A.m 09.01.22

32.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

344169

12/09.01.22

33.0

ALS41032130

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 ALS4-1032-130 Inserts M105819

or (see QSI 017)

A.m 09.01.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44224A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960JD10L

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 AN960JD10L

Washer

m 109632

a.m 09.01.220

35.0

MS27039108

Screw



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 MS27039-1-08

Screw

m 110469

a.m 09.01.220

36.0

D26511

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2651-1

Plugs

B44342

a.m 09.01.220

37.0

D26513

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2651-3

O-Rings

B41932

a.m 09.01.220

38.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS27039-4-06

Screw

m 109061

a.m 09.01.220

39.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN960JD416

Washer

m 108161

a.m 09.01.220

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 m109823

Sikaflex expire date: 09.11

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

a.m 09.01.22 ①

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B43801 ✓

a.m 09.01.22 ①

42.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw m110467 ✓

a.m 09.01.22 ①

43.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer m109632 ✓

a.m 09.01.22 ①

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 *M109883*

Sikaflex expire date: *09.11*

D2650-5
2-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: *DA 109917*

109-01261

A.M 09.01.22

45.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/01/27

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

inspect for foreing objets as per QSI 024

S 09/01/27

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-141

Location:

PPP Rev:

PPR 44 224

09/01/27

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02

Job Completion



JW 09.01.29

W/O:		WORK ORDER CHANGES					
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8 7 6 5 4 3 2 1

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

RELEASED
08-07-23

F

IES:
ATERIAL: N/A
FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

OLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
JNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
DENTIFICATION: NONE
EIGHT: N/A
VELD PER DART QSI 004

DAMAGE TOLERANCE ON FWD BEND:
HERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

3OND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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44224A

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW; INCCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
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DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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8 7 6 5 4 3 2 1

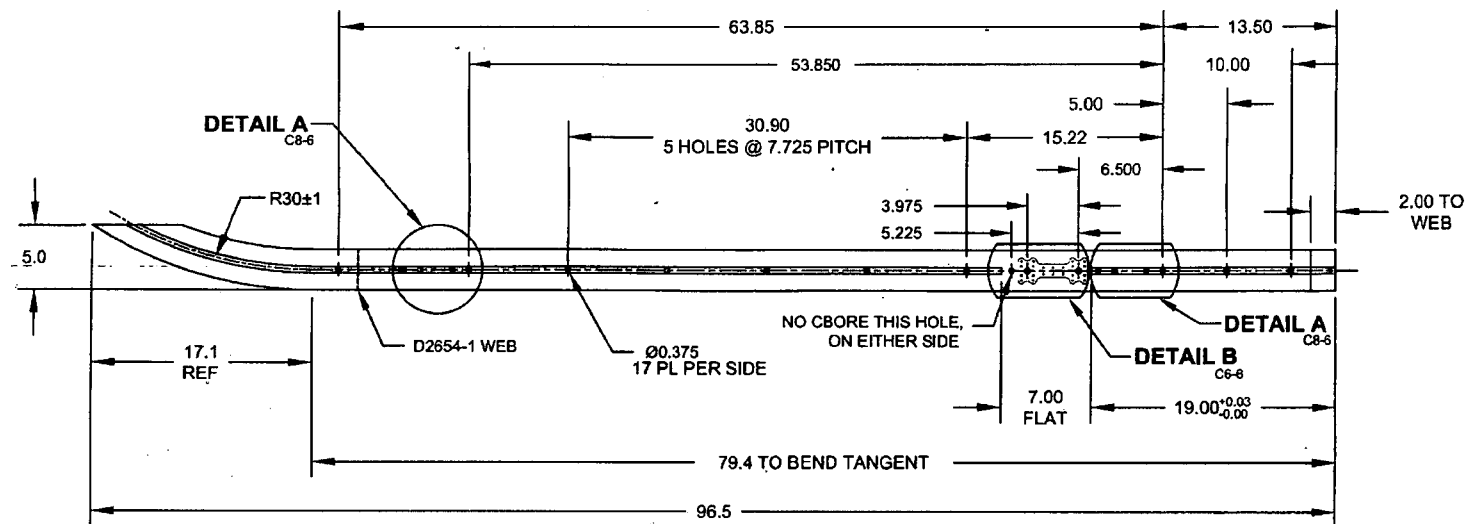
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

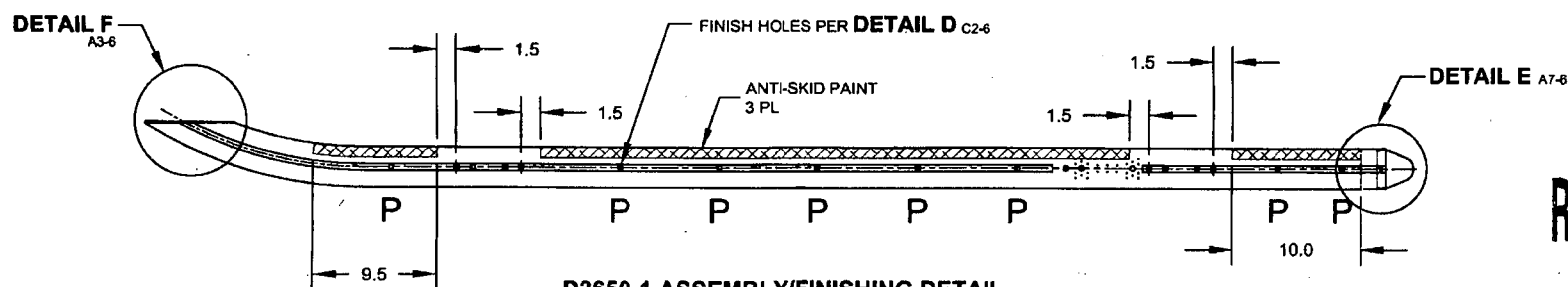
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

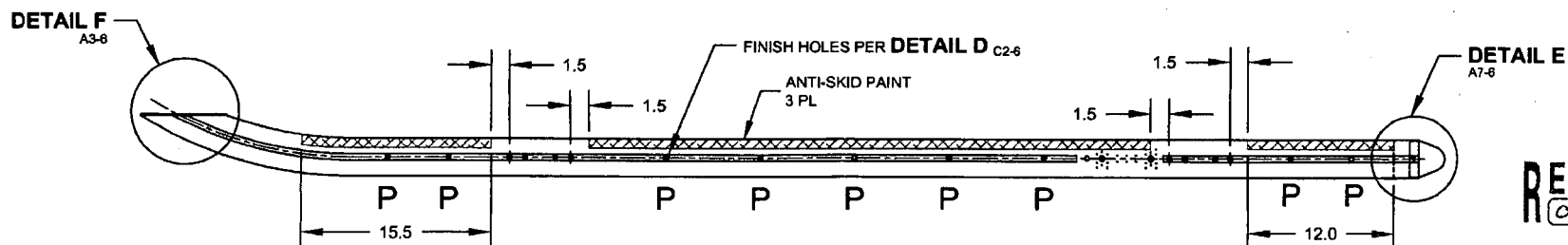
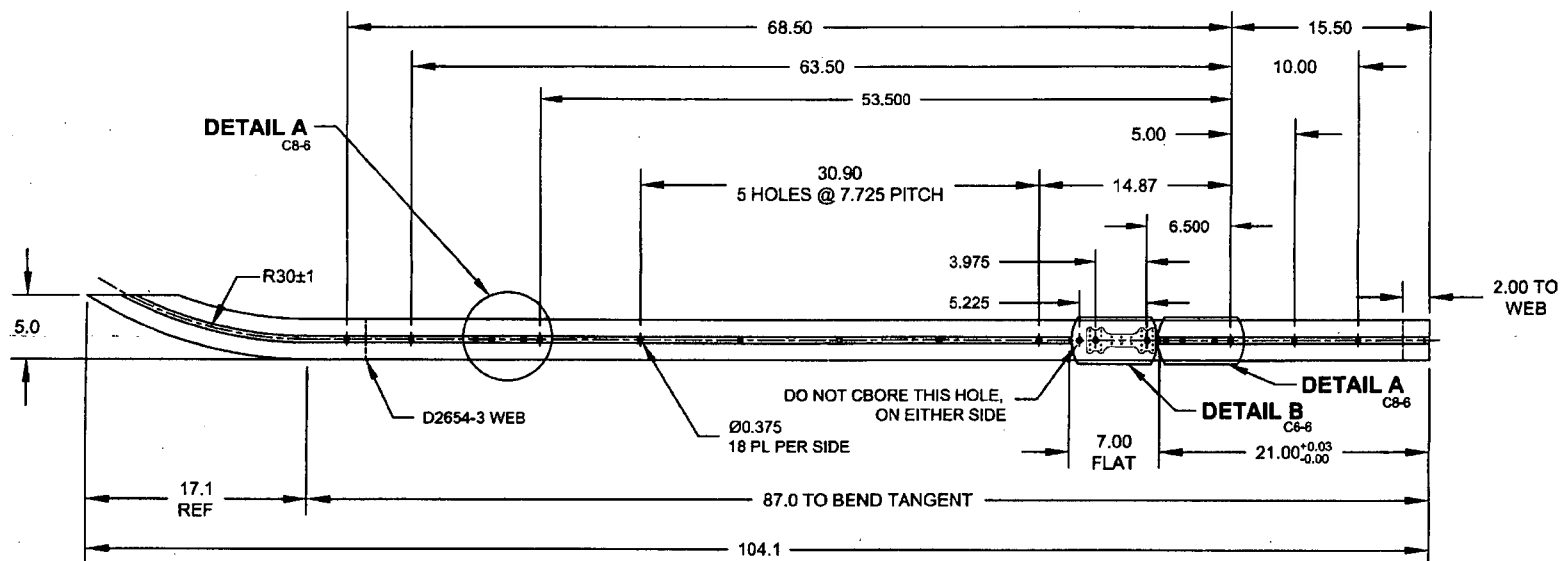
5

4

3

2

1



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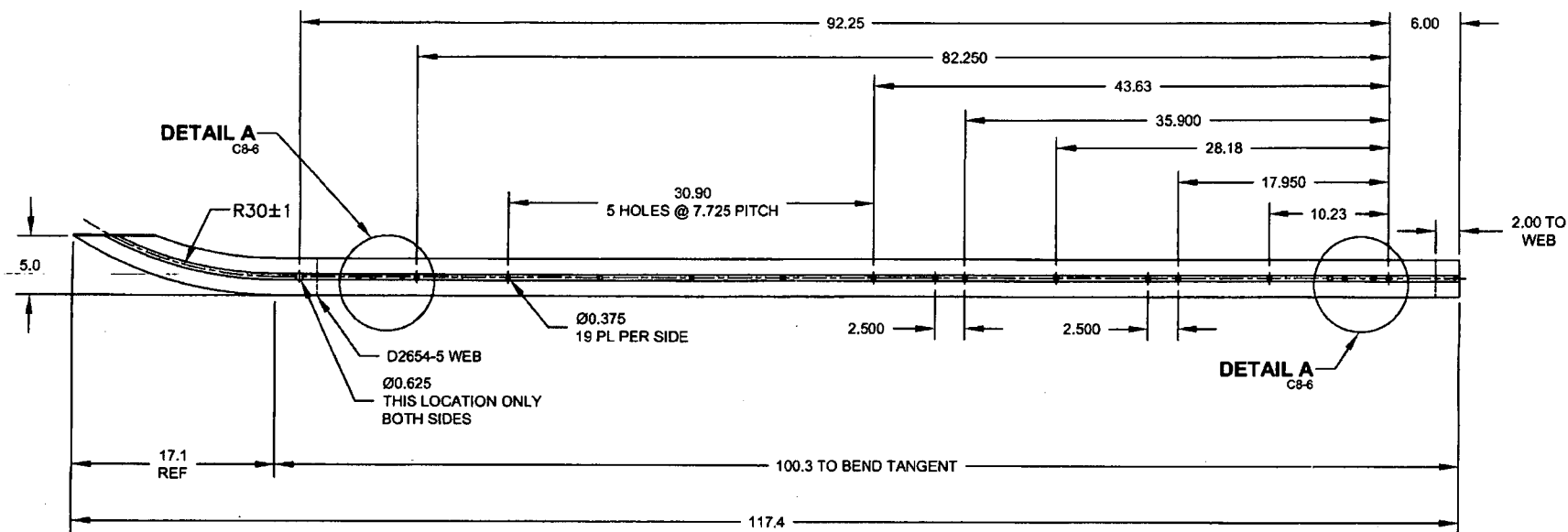
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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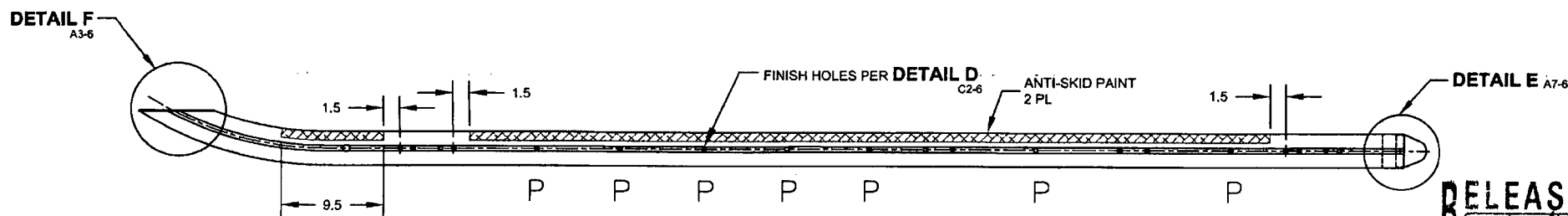
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D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

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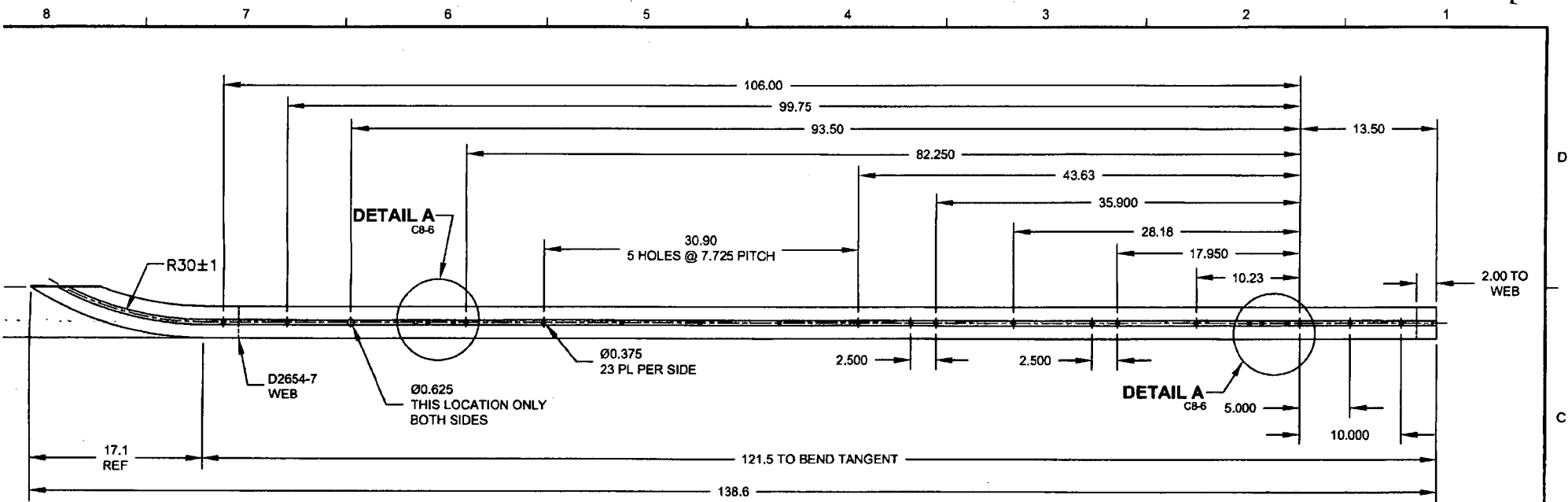
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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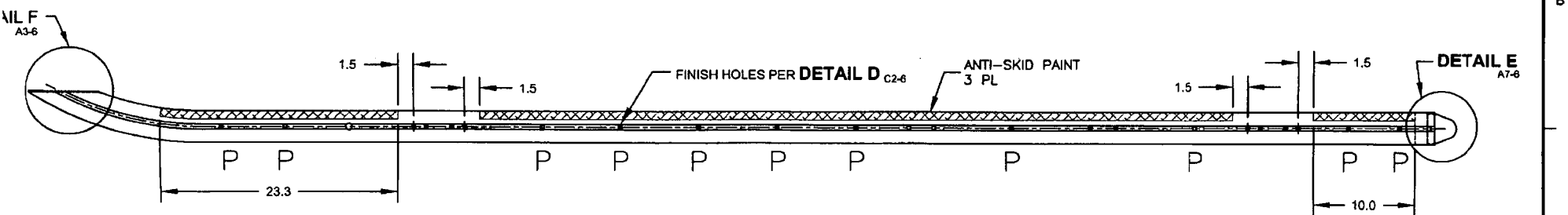
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2650-7 BENDING/DRILL DETAIL

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D2650-7 ASSEMBLY/FINISHING DETAIL

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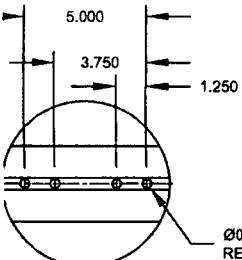
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

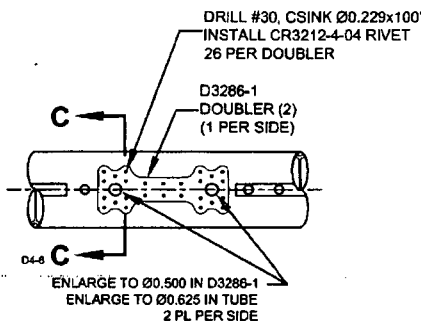
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

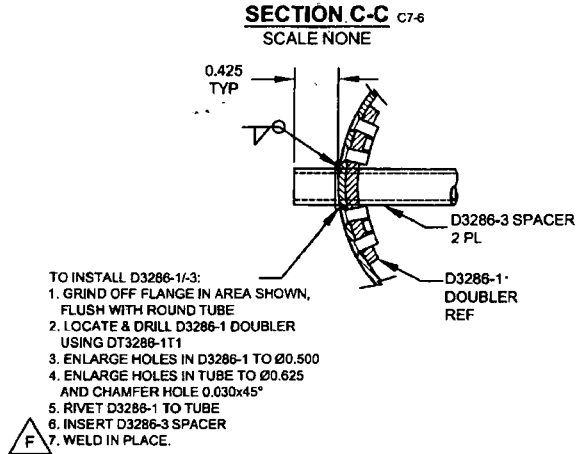
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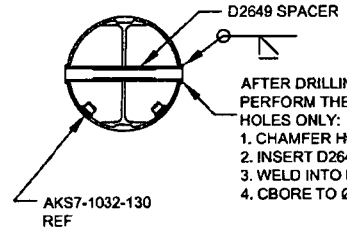
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5



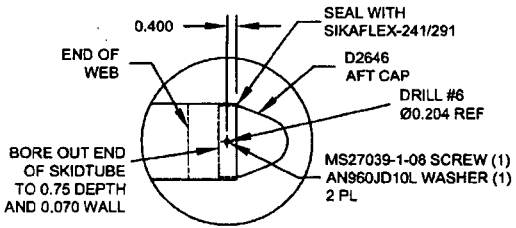
DETAIL B
SCALE 2X
C3-2
C3-3



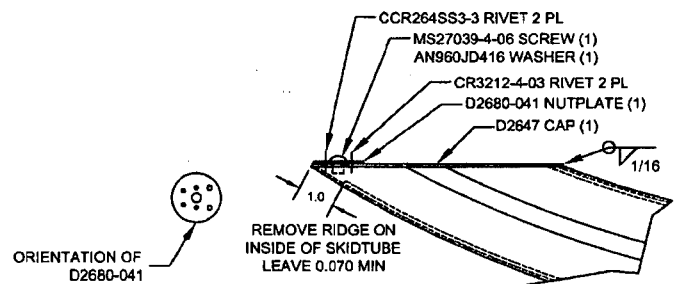
SECTION C-C
SCALE NONE
C7-6



DETAIL D
FOR 0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5







DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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08-09-2013

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 186

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barclay Elliot
Job number: B44225 A
Part number: A206-642-241
Description: 206 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Durl Date of Test Coupon 09/01/08
Welder Barclay Elliot Date of Test Coupon 09/01/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld